

# Work Order ID 55345

January 13, 2010 11:41:08 AM



Page 1

Item ID: D3704-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Escutcheon

Start Date: 1/13/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

*RL*

Date: 10-1-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



Bandsaw

Memo

0.00

*S.F. 10/01/15*

4

0

Jeaspa Bandsaw

CUT 3.00" LONG

110

0.00



HAAS 1

Memo

0.00

*ml 10/01/16*

4

1

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA807

DWG REV: B

FOLIO REV: 1A

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3704-3 PAR #: N/A Fault Category: Machinist NCR: Yes No DQA: 1A Date: 10.01.20  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1A Date: 10/01/26

NCR: <u>55345</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/16	110	1 part scrap. dem. Ø.446 too big Ø.500" RC. wrong tool in the folio	<u>AS</u> <u>AS</u>	destroy and replace Qty 1 Batch <u>M110936</u> Fix Folio to prevent from reoccurring	<u>AS</u> 10/01/16	<u>1A</u> 10/01/17	<u>AS</u> <u>AS</u>	<u>S</u> 10/01/16

NOTE: Date & initial all entries

# Work Order ID 55345

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Page 2

Item ID: D3704-3

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Item Name: Escutcheon

Start Date: 1/13/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

*OK 10/01/16*

*4 0*

Quality Control

130

*QC2 10-01-18*  
~~QC4 100% Inspect kits for completeness~~

0.00



QC

Memo

0.00

*B.A 10/01/18*

*4 0*

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

*BR 10-01-18*

*(4) 0*

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 55345**

Page 3

January 13, 2010 11:41:08 AM

Item ID: D3704-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Escutcheon

Start Date: 1/13/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00

10-01-10

(X4)

0



QC

Memo

0.00

Quality Control

160

Identify as per dwg &amp; Stock Location: 84

0.00



Packaging

Memo

0.00

Packaging

10-1-10 425

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/10

MF 10-1-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 13, 2010 11:41:13 AM

Page 1

Work Order ID: 55345



Parent Item: D3704-3



Parent Item Name: Escutcheon

Start Date: 1/13/10

Required Date: 1/20/10

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No				f	66.3728	1.0400			



6061-T6 Bar 1.50 x 1.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

66.3728

107461

11.84

110936

54.5328

1.040

SP 10/01/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order: 55345
Description: E SCUTCHED		Part Number: D3704-3
Inspection Dwg: D3704 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.22	$\pm .030$	1.221	—			
.610	$\pm .010$	.610	—			
$\varnothing .170$	$\begin{matrix} +.005 \\ -.001 \end{matrix}$	$\varnothing .173$	—			
$\varnothing .322 \times 100^\circ$	$\begin{matrix} +.010 \\ -.010 \end{matrix} \times \pm 1/2^\circ$	$\varnothing .330 \times 100^\circ$	—			
1.063	$\pm .010$	1.061	—			
2.125	$\pm .010$	2.125	—			
1.054	$\pm .010$	1.052	—			
.206	$\pm .010$	.206	—			
$\varnothing .440$	$\begin{matrix} +.005 \\ -.001 \end{matrix}$	$\varnothing .442$	—			
.90	$\pm .030$	.903	—			
.500	$\pm .010$	.502	—			
.125	$\pm .010$	.128	—			
R.06	$\pm .030$	R.060	—			
.625	$\pm .010$	.623	—			
R.156	$\pm .010$	R.156	—			
R.03	$\pm .030$	R.030	—			
.03 X 45°	$\pm .030 \times 1/2^\circ$	.030 X 45°	—			
$\varnothing .755$	$\begin{matrix} +.005 \\ -.001 \end{matrix}$	$\varnothing .755$	—			
.175	$\pm .010$	.173	—			
.218	$\pm .010$	.215	—			
.435	$\pm .010$	.435	—			
.220	$\pm .010$	.220	—			
.06 X 45°	$\pm .030 \times 1/2^\circ$	.035 X 45°	—			

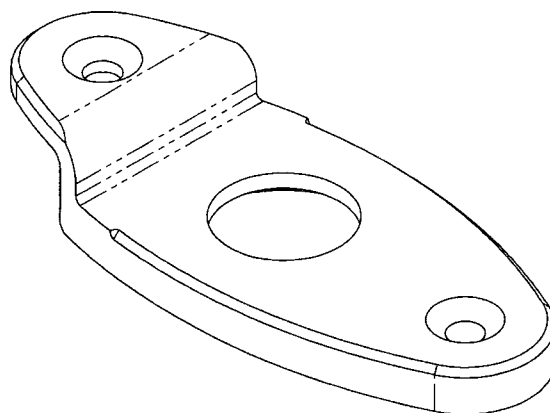
Measured by: <i>mf</i>	Audited by: <i>Y.A</i>	Prototype Approval:	N/A
Date: 10/01/16	Date: 10/01/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

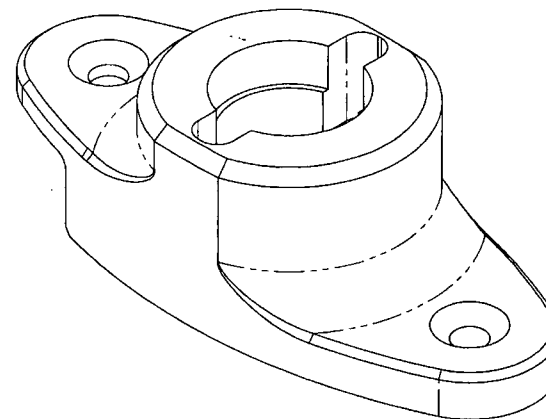


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RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 553-15

PM 10-1-13



**D3704-1 ESCUTCHEON**



**B D3704-3 ESCUTCHEON**

**RELEASED**  
07/04/09 MB

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3704-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:  
- D3704-1 = 0.04 lbs  
- D3704-3 = 0.11 lbs

B	ADDED D3704-3. REASON: COMPATIBILITY WITH AA1'S HANDLE.	MB	09.03.17
A	NEW ISSUE	MB	08.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.17		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3704** REV. B  
SHEET 1 OF 3  
TITLE **ESCUTCHEON** SCALE NTS

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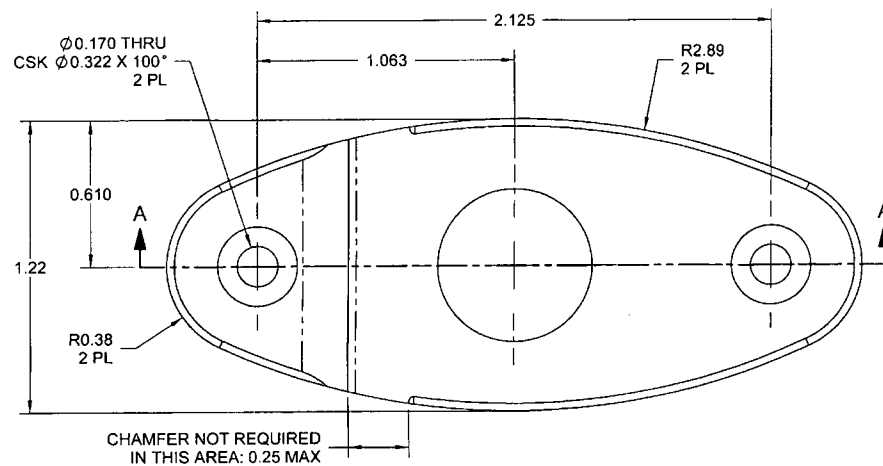
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

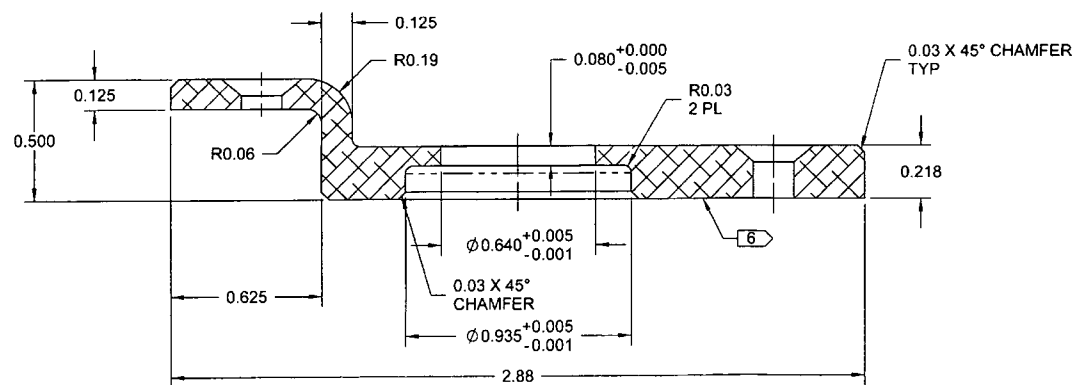
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3704-1 ESCUTCHEON**



**SECTION A-A**

**RELEASED**  
09/04/09

W10 35345

DESIGN		DART AEROSPACE LTD	REV. B
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3704	SHEET 2 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		ESCUTCHEON	NTS
DE APPR.			
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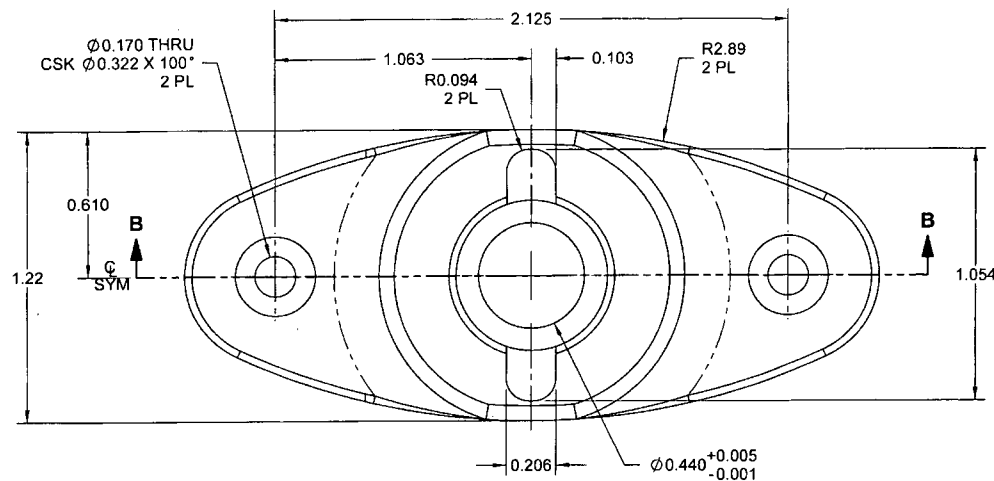
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

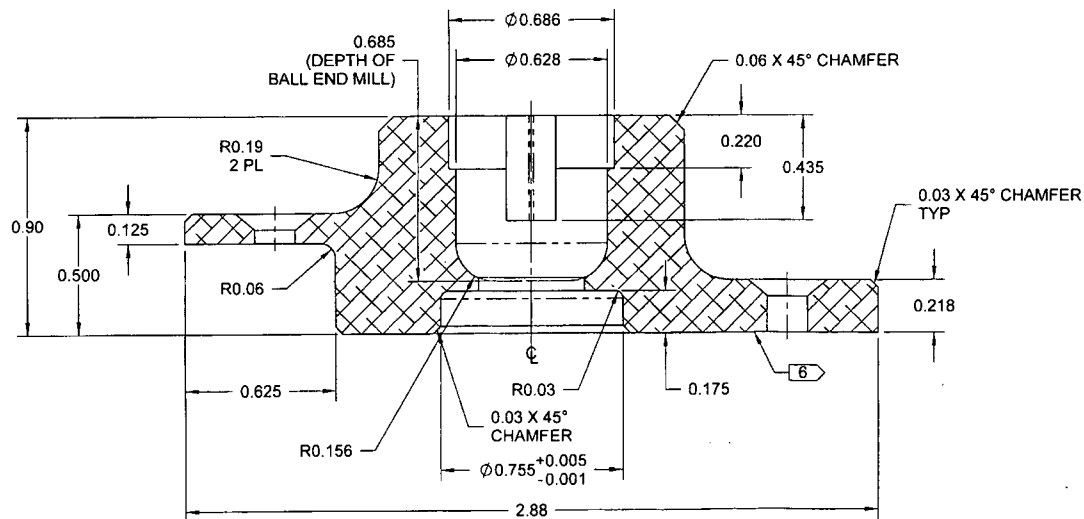
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3704-3 ESCUTCHEON**



**SECTION B-B**

**RELEASED**

WLO 55345

DESIGN		DART AEROSPACE LTD	REV. B
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3704	SHEET 3 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		ESCUTCHEON	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries